


# Work Order ID 77552

**\*77552\***

Page 1

Tuesday, December 13, 2011 2:38:39 PM

Item ID: D3912-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Eyebolt  
 Start Date: 12/13/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 1/5/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan:  Date: 12-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3912	B								

100 0.00  
**\*100\***  
 Doosan Memo 0.00  
 Doosan Lathe TURN AS PER FOLIO FA871 AND DWG  
 Prog Rev: B  
 Dwg Rev: 12/01/8  
 Deburr as required

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control 12/1/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 77552****\*77552\***

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	SL	12-01-09		(11)			
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: 91  Memo	0.00 0.00					12/1/9	SPD	
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							12/1/10 MF 12-01-09

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, December 13, 2011 2:38:44 PM

Page 1

Work Order ID: 77552

\*77552\*

Parent Item: D3912-1

\*D3912-1\*

Parent Item Name: Eyebolt

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000		Purchased	No			100	f	11.9310	0.25	2.631579			
*M303R2 000*									**			12/1/18	
303 ROUND BAR 2"													

Location

Loc Qty

Loc Code

MAT029

11.931

116656

1.427

116700

10.504

3 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 77552
<b>Description:</b> Eyebolt		<b>Part Number:</b> D3912-1
<b>Inspection Dwg:</b> D3912 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	.127	/			
Ø0.700	+/-0.010	.695	/			
Ø0.500	+/-0.010	.495	/			
0.90	+/-0.030	.50	/			
0.13 x 45°	+/-0.030 x 0.5°	.13 x 45°	/			
0.22	+/-0.030	.225	/			
0.75	+/-0.030	.752	/			
0.970	+/-0.010	.972	/			
1.72	+/-0.030	1.721	/			
1.20	+/-0.030	1.20	/			
0.625	+/-0.010	.625	/			
2.23	+/-0.030	2.229	/			
R0.13	+/-0.030	R.140	/			
R0.015	+/-0.010	R.015	/			
0.625	+/-0.010	.625	/			
Ø0.650	+/-0.010	Ø.650	/			
1.100	+/-0.010	1.100	/			
0.44	+/-0.030	.44	/			
R0.13	+/-0.030	R.125	/			
1.00	+/-0.030	1.00	/			
0.25	+/-0.030	.250	/			
0.88	+/-0.030	.880	/			
0.11	+/-0.030	.115	/			
Ø0.719	+0.010/-0.000	Ø.724	/			

<b>Measured by:</b> SA	<b>Audited by:</b> SL	<b>Preliminary Approval:</b>
<b>Date:</b> 12/1/8	<b>Date:</b> 12-01-09	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	10.08.09	Dimensions revised per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

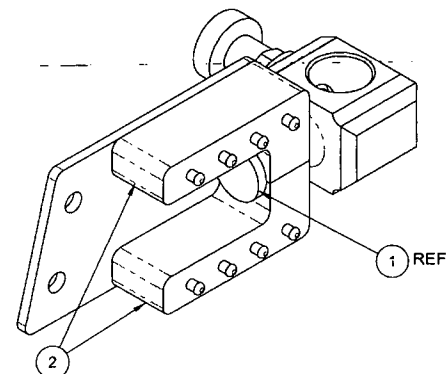
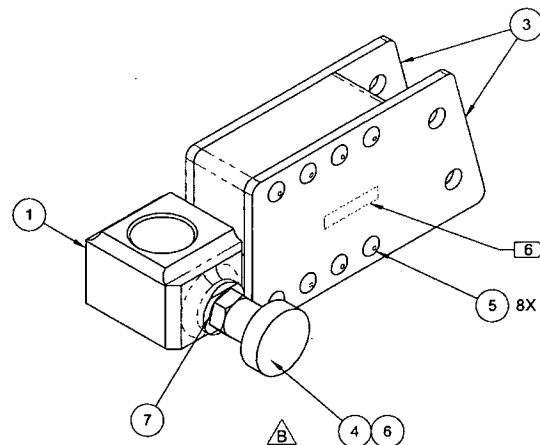
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



**SUPPLEMENTAL ISO VIEW**  
(EYEBOLT PLATE REMOVED  
TO SHOW INTERIOR FEATURES)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71552

11-12-13

**D3912-041 EYEBOLT RECEIVER ASSY**

- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING  
FINE POINT PERMANENT INK MARKER  
7) WEIGHT: -041: 1.58 lbs

**RELEASED**  
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV: MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JS		
CHECKED	JS		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS		
DATE	10.06.28		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B  
SHEET 1 OF 3  
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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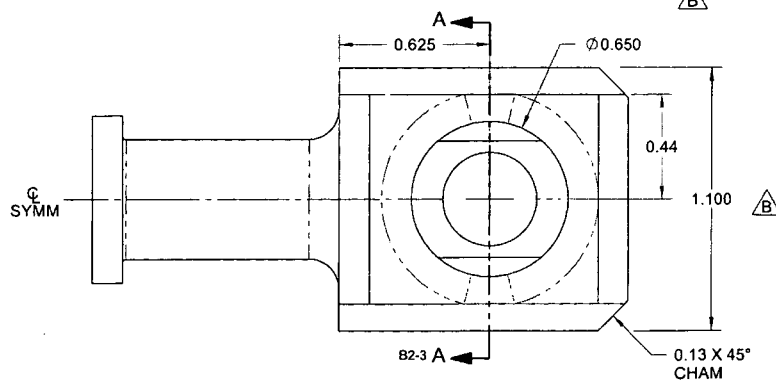
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



77552



RELEASE  
2010-07-16

- NOTES:**  
 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
 REF DART SPEC M303R OR M304R  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: ID AT ASSEMBLY  
 7) WEIGHT: 0.45 lbs

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3912	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>EYEBOLT RECEIVER ASSY</b>	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: ID AT ASSEMBLY  
7) WEIGHT: -3: 0.30 lbs  
              -5: 0.24 lbs

RELEASED  
2010-07-16

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3912</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>EYEBOLT RECEIVER ASSY</b>	NTS
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**NOTE:** Date & initial all entries